

605P

1. (Amended) A method for manufacturing a release-controlled pipe which mainly comprises a plurality of steps which are:

~~Mixing Formulation:~~ mixing a plurality of elastomer pellets and a binder ~~being mixed to said formulation~~, wherein said elastomer pellets ~~occupy~~ comprise 60 to 80 percent of the mixture and can be rubber material such as waste tires, ~~which and wherein~~ said binder ~~occupies~~ comprises 40 to 20 percent of the mixture and can be resin material;

~~First Hot Melt Extrusion and Cooling:~~ pouring said formulation ~~being poured~~ into a first melt extruder to form a rod-like extrudate, and then cooling said rod-like extrudate being cooled through a conveyor and a cooling unit;

~~Grinding and Blending:~~ grinding said rod-like extrudate being ground into ~~pieces~~ pellets, then being placed placing a portion of the pellets into a water-filled container and another portion of the pellets into a dry container thus producing dry ground pellets and wet ground pellets for collecting separately;

~~Second Hot Melt Extrusion:~~ mixing a mixture of dry ground pellets and wet ground pellets which were soaked in water, with a small amount of lubricant such as stearic acid, ~~being poured and pouring the mixture~~ into a secondary hot-melt extruder and using a pipe die head ~~being used for shaping to extrude and shape~~ a release-controlled pipe;

~~Cooling: said~~ cooling the extruded release-controlled pipe ~~extruded by means of said pipe die head being cooled and having a fixed shape through a~~ with water tank and a sprayer to fix the shape of the pipe, and then ~~being gathered~~ gathering the pipe using by a winder.

2. (Amended) A method for manufacturing a release-controlled pipe as recited in claim 1, wherein said ground pellets are soaked in said water-filled container for more than one day ~~to get enough water content.~~